

Work Order ID 140735

140735

Page 1

Monday, January 18, 2016 7:21:58 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 1/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: JAN 18 2016 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
DSI9690	A

100 Document Control 0.00

100

DC:

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

MAR 11 2016

110

0.00

110

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 31001

Description: D2445 Baggage Door

Supplier: Delastek FSC

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

DAS
28
9-89

MAR 14 2016

DAS
13
9-89

JAN 18 2016

MAR 09 2016

DAS
13
9-89

16.02.24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Monday, January 18, 2016 7:21:58 AM

140735

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/18/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS

C

9-89

155

Pick Kit

0.00

155

Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS

28

9-89

150

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : ☐																							

Work Order ID 140735

Monday, January 18, 2016 7:21:58 AM

140735

Page 4

Item ID: D350-588-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Door Assembly
 Start Date: 1/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00				1X	DAS 28 9-89	DAS 27 9-89	MAR 14 2016
Packaging	Location :FG021								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MCS MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, January 18, 2016 7:22:01 AM

Page 1

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P		Purchased	No			110	Each	0.0000	1	1			
D2445P									**				
Aft Door Assembly													
AN526C832R9		Purchased	No			140	Each	280.0000	8	8			
AN526C832R9									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		280							
				M132823		130							
				M133932		150							
D2143		Manufactured	No			140	Each	21.0000	1	1			
D2143									**				
Hinge Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST003		21							
				121806		21							
D2144		Manufactured	No			140	Each	11.0000	1	1			
D2144									**				
Hinge Doubler													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST002		11							
				114332		11							

1x SP16-02-17

DAS
07
9-89

16/02/24

DAS
07
9-89

16/02/24

DAS
07
9-89

16/02/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 2

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2463 Manufactured No 140 f 632.5891 7.25 7.25

D2463

1/2" Seal (\$Per Foot)

DAS
07
9-89

16/02/24

Location	Loc Qty	Loc Code
ST409	500	
140013	500	
ST638	132.5890683	
125469	132.589068	

7.25

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585 Manufactured No 140 Each 0.0000 2 2

D2585

Latch Clamp

D2586 Manufactured No 140 Each 75.0000 2 2

D2586

Door Latch

DAS
07
9-89

16/02/24

Location	Loc Qty	Loc Code
FG	4	
119746	2	
138048	2	
OVER002	25	
140535	25	
ST483	46	
139228	46	

2.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 3

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

140

Each

26.0000

2

2

D2621

Latch Plate

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FG

2

88616

2

ST012a

24

127749

24

2

D2857-1

Manufactured No

140

Each

18.0000

1

1

D2857-1

Hinge Bracket

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FG

5

121829

2

82261

2

91914

1

ST012

13

121829

1

133964

12

1

D2857-2

Manufactured No

140

Each

16.0000

1

1

D2857-2

Hinge Bracket

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FG

5

130848

2

78904

3

ST012

11

133903

11

1

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

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Monday, January 18, 2016 7:22:02 AM

Page 4

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

1,287.000

8

8

MS21042L 08

Nut

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

CA	101	
m129682	101	
GA	3	
m133134	3	
ST303	1140	
m133483	140	
m133922	1000	
ST304	43	
m128401	32	
m131317	11	

MS21042L3

Purchased

No

140

Each

1,042.000

2

2

MS21042L 3

Nut

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FP001	134039.	163
m133790		163
GA		195
m133790		195
ST304		684
m133790		684

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 5

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

140

Each

506.0000

2

2

MS27039-1-15

Screw

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

GA

21

m127916

21

ST280

485

m132640

485

NAS1149D0363J

Purchased

No

140

Each

1,046.000

2

2

NAS1149D0363.J

Washer

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

GA

108

m130799

108

ST263

938

m133790

438

m133932

500

NAS1149DN832J

Purchased

No

140

Each

957.0000

8

8

NAS1149DN832.J

Washer

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST270

873

M131697

873

AN526C1032R7

Purchased

No

155

Each

188.0000

2

2

AN526C1032R7

Screw

DAS
28
9-89

MAR 11 2016

DAS
6 2
9-89 9-89

Location

Loc Qty

Loc Code

ST327

188

M128403

188

Monday, January 18, 2016 7:22:02 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
			☐ OTHER : _____					

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 6

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R8

Purchased No

155

Each

205.0000

8

8

AN526C832R8

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST327

205

m129706

94

m129764

11

m133932

100

D2150

Manufactured No

155

Each

24.0000

2

2

D2150

Packer Doubler, Hinge

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

24

121844

24

D2151

Manufactured No

155

Each

15.0000

2

2

D2151

Packer Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

15

121825

15

D2153

Manufactured No

155

Each

18.0000

1

1

D2153

Door Prop

Location

Loc Qty

Loc Code

ST362

18

131670

18

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 7

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2154

Manufactured No

155

Each

31.0000

1

1

D2154

Bracket, Stud

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

31

118894

31

D2237

Manufactured No

155

Each

10.0000

2

2

D2237

Striker Plate

DAS
28
9-89

Location

Loc Qty

Loc Code

ST004

10

136090

10

D2461

Manufactured No

155

f

295.0074

7.25

7.25

D2461

Neoprene 'D' Seal (\$Per Foot)

DAS
38
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST407

295.00737

128447

295.00737

(D2461-0870) cut (1) at 87.00"
**** per kit****

D2589

Manufactured No

155

Each

7.0000

1

1

D2589

Keys, Key Chain

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008

7

132942

7

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

DAS
6
9-89

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 8

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

24.0000

1

1

D2690-17

Cable

DAS
28
9-89

Location

Loc Qty

Loc Code

ST012a

24

112206

6

120107

3

121750

6

140042

9

D2858-1

Manufactured No

155

Each

18.0000

1

1

D2858-1

Hinge Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

77019

2

ST012

16

121400

4

133091

12

D2858-2

Manufactured No

155

Each

8.0000

1

1

D2858-2

Hinge Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

77020

2

ST012

6

121563

6

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 9

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D5080-041 Manufactured No

155 Each 43.0000 2 2

D5080-041

Striker Plate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST148

43

121798

2

126722

17

128722

24

FG-778150-550-ROL

Purchased No

155 sf 600.1463 1

1.333333

***FG-778150-550-ROL ***

7781 9oz Glass 50x125yd

DAS
28
9-89

Location

Loc Qty

Loc Code

CA2

600.1463415

M127701

600.146342

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased No

155 Each 2,922.000 12 12

MS20426AD3-4

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

2811

m131697

2811

ST312

111

m127432

111

MS20470AD4-5

Purchased No

155 Each 1,466.000 18 18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1012

m133860

1012

ST310

454

m133860

454

MAR 11 2016

Monday, January 18, 2016 7:22:02 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 10

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

1,287.000

10

10

MS21042L08

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

3

m133134

3

ST303

1140

m133483

140

m133922

1000

ST304

43

m128401

32

m131317

11

DAS
28
9-89

10

MS21042L3

Purchased

No

155

Each

1,042.000

4

4

MS21042L3

Nut

DAS
6
9-89

134039

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

195

m133790

195

ST304

684

m133790

684

DAS
28
9-89

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, January 18, 2016 7:22:02 AM

Page 11

Work Order ID: 140735

140735

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

503.0000

2

2

MS27039-08-11

SCREW

DAS 6 27 9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

over006

450

m133769

450

ST278

53

m133363

53

NAS1149D0363J

Purchased

No

155

Each

1,046.000

2

2

NAS1149D0363.J

Washer

134055

DAS 6 27 9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

108

m130799

108

ST263

938

m133790

438

m133932

500

NAS1149DN832J

Purchased

No

155

Each

957.0000

16

16

NAS1149DN832.J

Washer

DAS 27 9-89 9-89 MAR 11 2016

DAS 28 9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST270

873

M131697

873

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

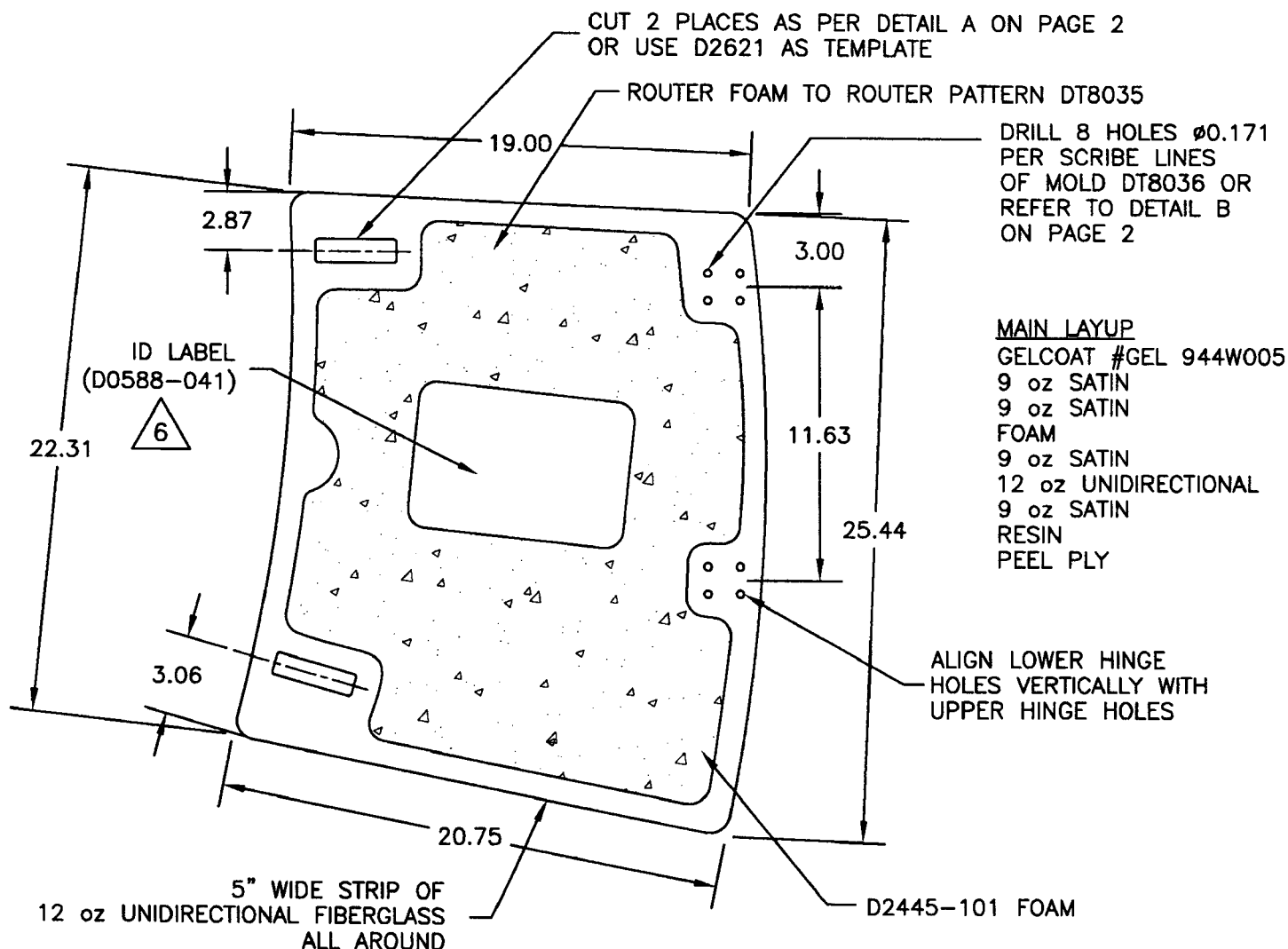
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYNCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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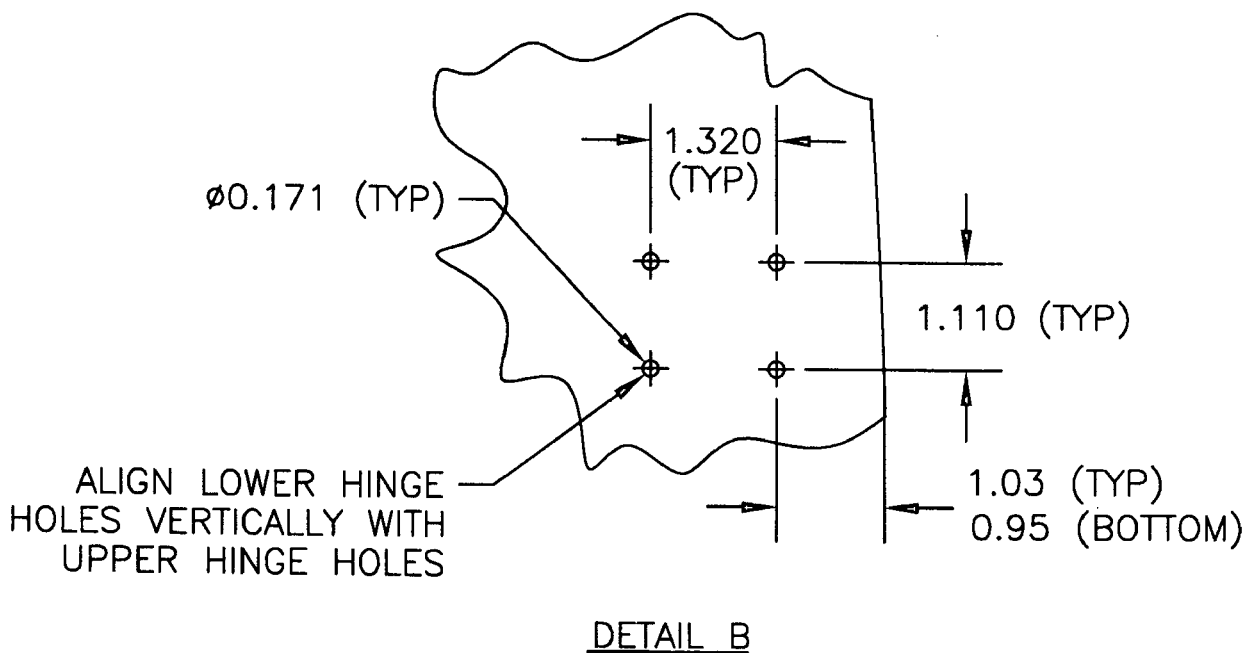
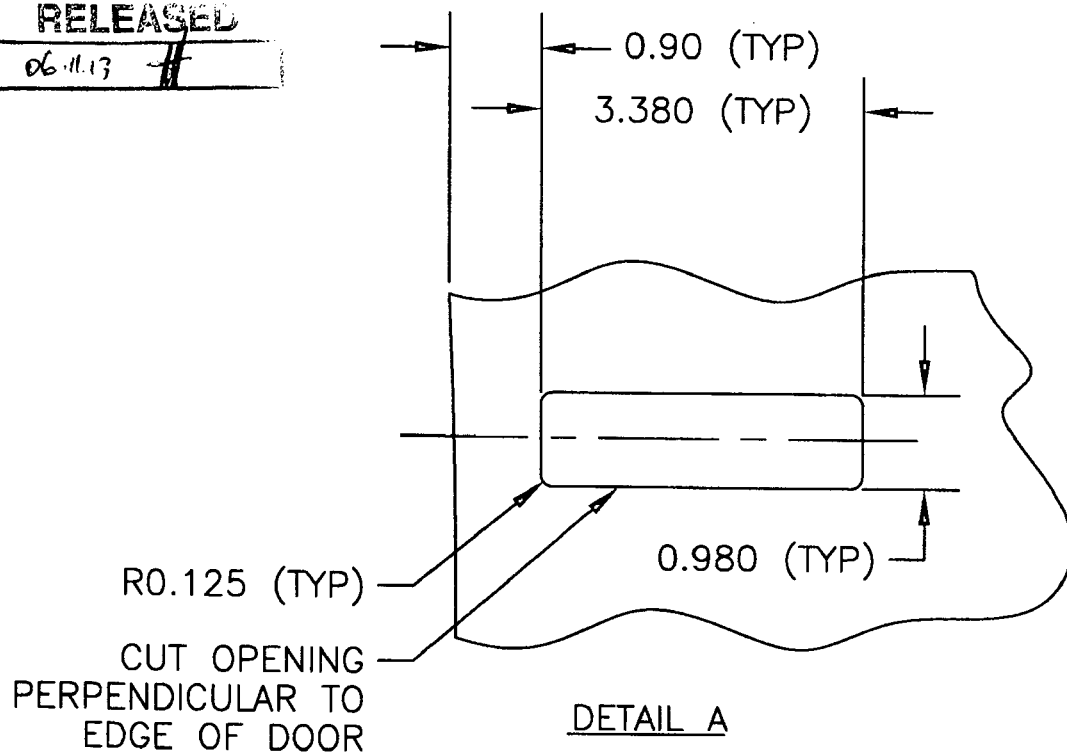
STOP COPY
TO BE USED
FOR LAMINATING
DO NOT USE FOR
COPYING
140735.mcs
1001-18



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED

06.11.13 *[Signature]*



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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. 0
REF TCCA STC SH92-41
FAA STC SH1012NE

1.0 PURPOSE:

The purpose of this Dart Service Instruction is to provide customers with directions to install a modified striker plate that will provide more clearance around environmental/conductive seals that protrude inboard of the door frame structure on AS355 N/NP models.

2.0 PROCEDURE:

- 1) Install D350-588-011/-041 per Section 3.1/3.2 of D350-588 as applicable, except do not install D2237 striker plates per item 10 of Section 3.1.
- 2) Remove the aft environmental/conductive seal to gain access to the door structure.
- 3) Using a fine point marker, mark location of both striker plates based on door latch location.
- 4) If D2237 Striker Plates are currently installed, remove both striker plates by drilling out rivets.
- 5) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes into the aft bulkhead.
- 6) Drill out both rivets on the aircraft skin adjacent to the striker plate assemblies.
- 7) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes from the aircraft skin to the striker plate assembly.
- 8) Deburr holes and remove all sharp edges.
- 9) Touch up all holes in aluminum with chemical conversion coating in accordance with MIL-DTL-5541.
- 10) Apply 0.125" thick layer of PR-1775B ProSeal to the face of D5080-041 per Figure 1.
- 11) Install D5080-041 striker plate assemblies to the aft bulkhead using CR3213-4 rivets of a suitable length, and to the skin of the aircraft using PR-1775B coated CR3213-4 rivets of a suitable length.
- 12) Reinstall environmental/conductive seal using manufacturers recommended procedure.
- 13) Install gas strut or cable assembly per D350-588 Figure 5.
- 14) Adjust both latch mechanisms to ensure adequate compression of door seal and that door skin is flush.
- 15) Check door for proper operation by opening and closing the door, and ensure latches fully lock.

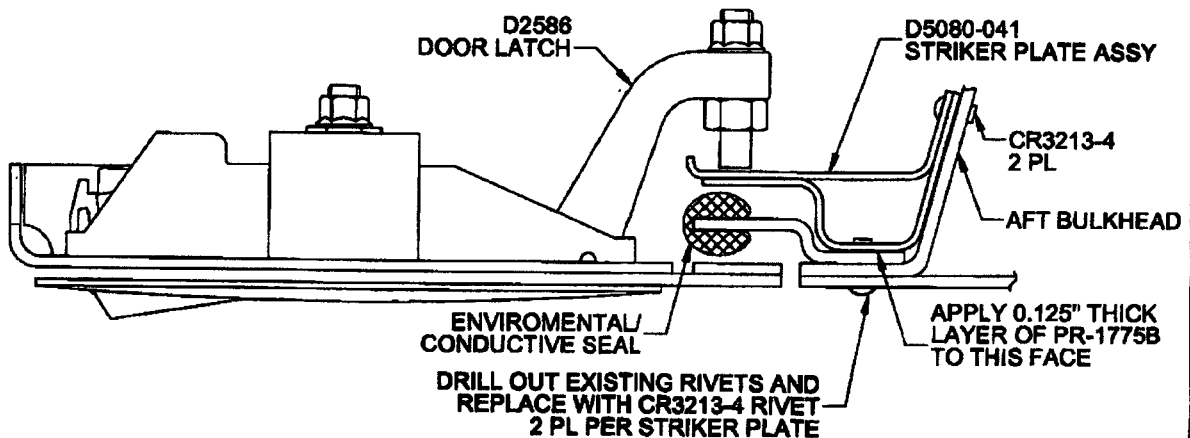


Figure 1 Striker Plate

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

A	NEW ISSUE	ML	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9690	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

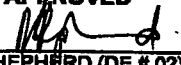
This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31001**

Purchase Order Date 1/14/2016

PO Print Date 1/18/2016

Page Number 1 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JAN 18 2016

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	D2445P	Aft Door Assembly ✓	2/8/2016 Yes 2/8/2016		1.00 Each	\$605.00	\$605.00
	AS PER DWG D2445 REV. D B140735						
						Line Total:	\$605.00
2	D2445P	Aft Door Assembly	2/8/2016 Yes 2/8/2016		1.00 Each	\$605.00	\$605.00
	AS PER DWG D2445 REV. D B140737						
						Line Total:	\$605.00
3	D2445P	Aft Door Assembly	2/8/2016 Yes 2/8/2016		1.00 Each	\$605.00	\$605.00
	AS PER DWG D2445 REV. D B140738						

Note:

1/18/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

11/02/2016

Commande : 2356
Référence : PO #31001/1-6

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tél. : 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D2445P ✓	Aft Door Assembly B140735 PO item: 31001/1 Lot: 2016-01-18	1		
D2445P	Aft Door Assembly B140737 PO item: 31001/2 Lot: 2016-01-20	1		
D2445P	Aft Door Assembly B140738 PO item: 31001/3 Lot: 2016-01-26	1		
D2445P	Aft Door Assembly B140739 PO item: 31001/4 Lot: 2016-02-03	1		
D2445P	Aft Door Assembly B140740 PO item: 31001/5 Lot: 2016-02-04	1		
D2445P	Aft Door Assembly B140741 PO item: 31001/6 Lot: 2016-02-05	1		
CANADIAN CURRENCY				

Transport :

Nb colis :

Marchandise reçue :

Réf. :



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

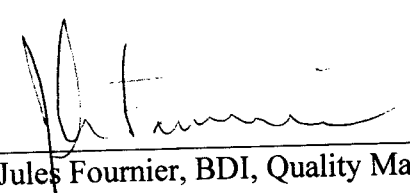
Customer P/O Number: 31001

DAS
9
9-89

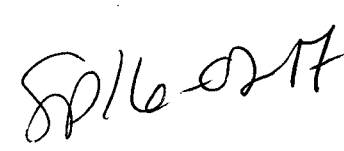
<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	1	D2445P	D2445 Rev D	Aft Door Assembly B140735	DAE007-005	2016-01-18
2	1	D2445P	D2445 Rev D	Aft Door Assembly B140737	DAE007-006	2016-01-20
3	1	D2445P	D2445 Rev D	Aft Door Assembly B140738	DAE007-007	2016-01-26
4	1	D2445P	D2445 Rev D	Aft Door Assembly B140739	DAE007-008	2016-02-03
5	1	D2445P	D2445 Rev D	Aft Door Assembly B140740	DAE007-009	2016-02-04
6	1	D2445P	D2445 Rev D	Aft Door Assembly B140741	DAE007-010	2016-02-05

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Jules Fournier, BDI, Quality Manager

Date:


2016-02-11



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO31001

Purchase Order Date 1/14/2016

PO Print Date 3/9/2016

Page Number 1 of 3

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name	Buyer	Chantal Lavoie
Vendor Phone 450-357-1344 ext303	Customer POID	
Vendor Fax 450-357-1194	Customer Tax #	10127-2607
Ship To Contact	Terms	Net 30
Ship To Phone	Currency	CAD
	FOB	Destination-Collect
Ship Method		
Ship Acct		

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
8	140735	D2445 AFT DOOR ASSEMBLY ✓	3/9/2016 Yes	1.00	\$0.00
	RE-WORK		3/9/2016		
					Line Total: \$0.00
9	140737	D2445 AFT DOOR ASSEMBLY	3/9/2016 Yes	1.00	\$0.00
	RE-WORK		3/9/2016		
					Line Total: \$0.00

\$ 16 038

3/9/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél.: 450 357-1344

Bon de livraison

04/03/2016

Commande : 2371
Référence : PO #31001/1-6

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D2445P ✓	Aft Door Assembly B140658 140735 PO item: 31001/1 Lot: 2016-01-18 ✓	Spille 03-8		
D2445P	Aft Door Assembly B140702 PO item: 31001/2 Lot: 2016-01-20			
D2445P	Aft Door Assembly B140703 PO item: 31001/3 Lot: 2016-01-26			
D2445P	Aft Door Assembly B140704 PO item: 31001/4 Lot: 2016-02-03			
D2445P	Aft Door Assembly B140705 PO item: 31001/5 Lot: 2016-02-04			
D2445P	Aft Door Assembly B140706 PO item: 31001/6 Lot: 2016-02-05			
CANADIAN CURRENCY				
NO CHARGE : REPAIRS				

Transport : _____

Réf. : _____

Nb colis : _____

Marchandise reçue : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

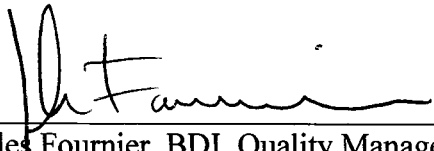
Customer P/O Number: 31001

Certificate Revision : A

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	1	D2445P	D2445 Rev D	Aft Door Assembly B140735	DAE007-005	2016-01-18
2	1	D2445P	D2445 Rev D	Aft Door Assembly B140737	DAE007-006	2016-01-20
3	1	D2445P	D2445 Rev D	Aft Door Assembly B140738	DAE007-007	2016-01-26
4	1	D2445P	D2445 Rev D	Aft Door Assembly B140739	DAE007-008	2016-02-03
5	1	D2445P	D2445 Rev D	Aft Door Assembly B140740	DAE007-009	2016-02-04
6	1	D2445P	D2445 Rev D	Aft Door Assembly B140741	DAE007-010	2016-02-05

Part received from Dart for modification by FDC to suite required tolerance for hardware installation. Composite repair process performed as per Dart's QSI 037 Issue 2 Composite Repair Manual.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Jules Fournier, BDI, Quality Manager

Date: 2016-03-04

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Work Order ID 140735

140735

Page 1

Monday, January 18, 2016 7:21:58 AM

Item ID: D350-588-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Door Assembly
 Start Date: 1/18/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JAN 18 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2445/D350-588	Rev D/D								
DSI9690	A								

100 Document Control 0.00
 100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-588-041 CHG003

MLJ MAR 11 2016

110 PURCHASING 0.00
 110
 Purchasing Memo 0.00
 Purchasing Issue P/O: 31001
 Description: D2445 Baggage Door
 Supplier: Delastek AKC
 Ship to Delastek (1) D0588-041 label
 Certification of Conformity and process sheet from Delastek is required.

AKC
 16.02.24

DAS 13 9-99 JAN 18 2016
 DAS 13 9-99 MAR 09 2016
re-mach.